

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021514**Date Inspected:** 05-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr. Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

Trial Assembly:-

SMAW welding of Weld Joint OBW12C-001(12BW+12CW,BP-BP), and Critical Welding Repair Report(CWR)B-CWR2821 Rev.2, Welder is identified as 046709; ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-FCM-Repair-1.

SMAW welding of Weld Joint DP3054-001-009(12BW,DP-LD,CB Side), and Welding Repair Report(WR)B-WR20333 Rev.0, Welder is identified as 040611; ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair-1.

SMAW welding of Weld Joint SEG3004J-103,104 (12AW Side, Deck panel to I stiffener Holdback welds ), and Welder is identified as 067752; ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables

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appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of Weld Joint SEG3004Y-134,135 (12AW Side, Deck panel to I stiffener Holdback welds ), and Welder is identified as 068764; ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

CB#17:-

SMAW welding of Weld Joint CB3001A-017-003 (CB#17,Side plate to bottom panel ), And Welder is identified as 044504; ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of Weld Joint DP3038-017-005~008 (CB#17,Deckpanel to I stifener ), and Welder is identified as 040270; ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of Weld Joint DP3038-017-009~012 (CB#17,Deckpanel to I stifener ), and Welder is identified as 040378; ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 08460.

### Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as 12BW+12CW Bottom Panel T Rib Holdback welds. The weld designations reviewed are as follows.

1. BP3022-001-034,035,036
2. BP3023-001-025,026,035,036
3. BP3024-001-025,026,027
4. BP3025-001-029,030,031
5. BP3026-001-020,021,030,031
6. BP3027-001-020,021,022

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for

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your project.

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**Inspected By:** Tharikoppada,Reddy

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer